

Tuesday, 09/12/2008 9:39:02 AM
Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HAT BIN (206-L/L!)
 Job Number : 43954
 Estimate Number : 13677
 P.O. Number :
 This Issue : 09/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R&D THERMOFORMING
 Previous Run :
 Written By :
 Checked & Approved By : JUD 08.12.09
 Comment : Est. Rev. A 08.12.03 New Issue DL

Part Number : D38451
 Drawing Number : D3845-1
 Project Number : IN0002
 Drawing Revision : PROTOTYPE
 Material : MKYD6185S080P362015
 Due Date : 16/12/2008 Qty: 1 Um: Each

*PROTOTYPE
08.12.22*

Additional Product

PROTOTYPE
08.12.03 #

Job Number:



*UPDATED
01.12.22*

Seq. #: Machine Or Operation: Description : *PER TEST 01.12.16*

1.0 MKYD6185S080P362015 6185 KYDEX .080"



MATERIAL CERTIFICATION



Comment: Qty.: 10.8056 sf(s)/Unit Total: 10.8056 sf(s)
 6185 Kydex .080"

REQ'D UPON DELIVERY

M109703 DL 08.12.10

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

DL 08.12.10

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

DL 08.12.10

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3845-1 and folio (FTA9255 Prototype) using tool DT 9255

Dwg. Rev. PROTOTYPE

Folio Rev. A

DL 08.12.10

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

DL 08.12.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (206-L/L!)

Job Number: 43954

Part Number: D38451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



BB 08/12/11



Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/12/11 X1

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08-12-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



PO 08.12.12



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY
NOT FOR STOCK
PO 08.12.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*08-12-15 Prototype
with Deviations per FAS
attached.*

08.12.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

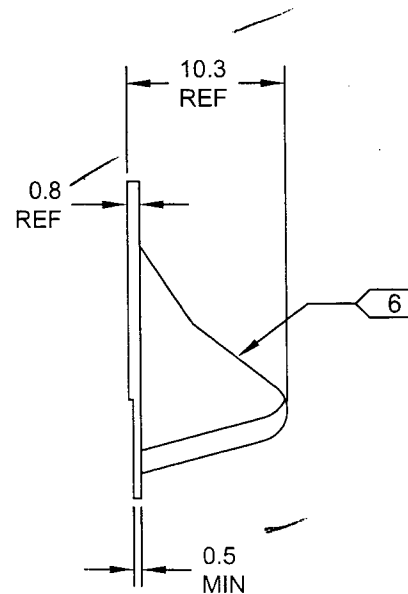
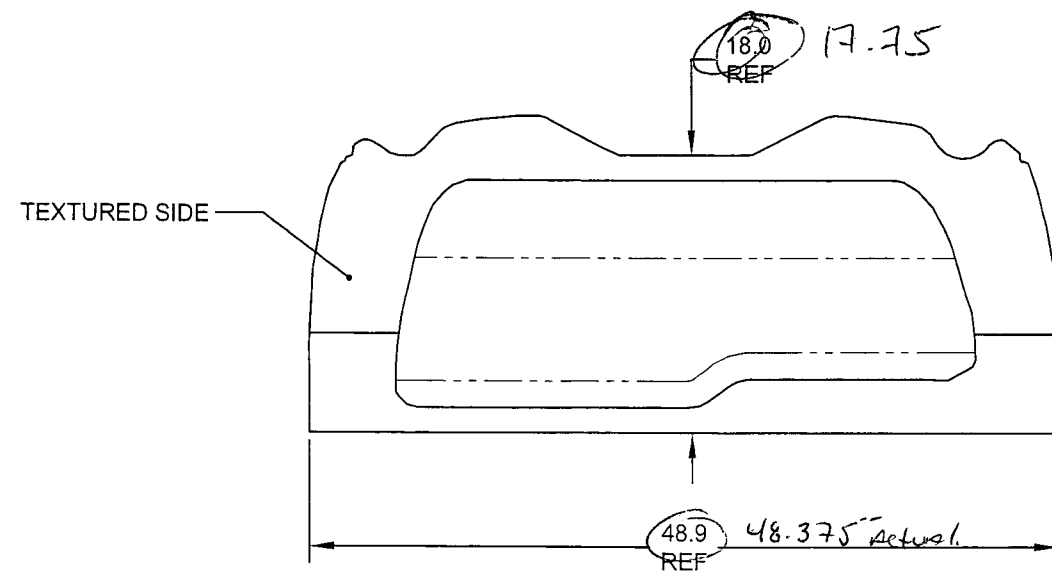
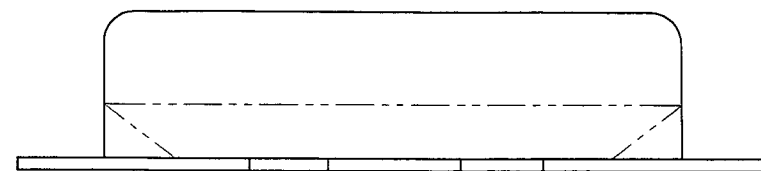
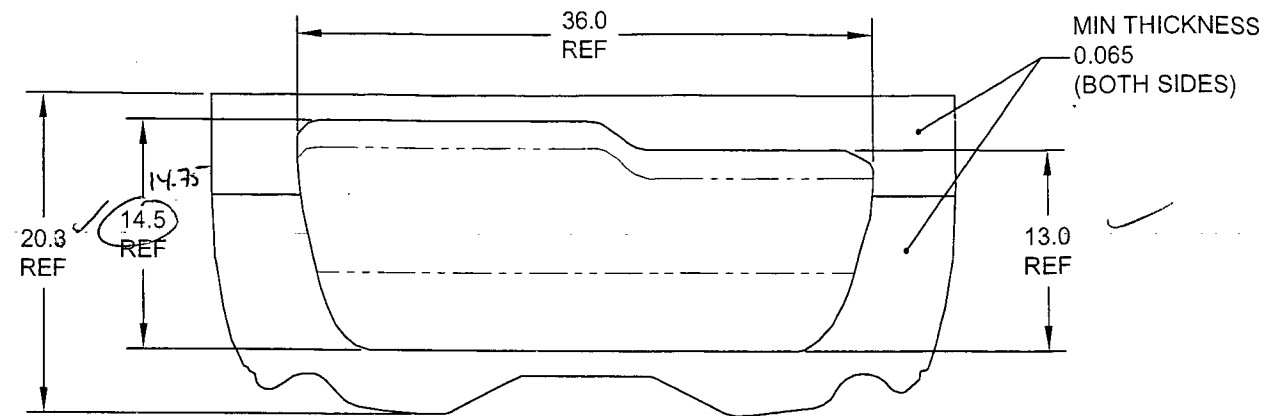
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3845-1 HAT BIN

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3845-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.0 lbs - xxx
- 8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.08 *PH*

A	NEW ISSUE	PH	08.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3845	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HOT BIN	NTS
DATE	08.10.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 43954
Description: Flat Bin LFL / Prototype		Part Number: 03845-1
Inspection Dwg: 03845	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	N/A			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			Air holes visible on the top section + thin inside corners.

Measured by: <i>[Signature]</i>	Date: 08-12-12
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	Min	0.055		✓	M.C.	At it's lowest @ 0.060" min.
14.5 (Ref)	± 0.100	14.75		✓		Review dim
20.3 (Ref)	± 0.100	20.3	✓			
36.0 (Ref)	± 0.100	36.0	✓			
13.0 (Ref)	± 0.100	13.06	✓			
18.0 (Ref)	± 0.100	17.75		✓		Review dim.
46.9 (Ref)	± 0.100	46.375		✓		Review dim
10.3 (Ref)	± 0.100	10.35	✓			
0.8 (Ref)	± 0.100	0.78	✓			(depends on how much trimmed)
0.5 (Ref)	± 0.100	0.5	✓			

Measured by: <i>[Signature]</i>	Date: 08-12-12
Audited by: <i>PR</i>	Date: 08-12-12
Prototype Approval: <i>PR</i>	Date: 06-12-12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: 8/10/24

Batch No: M109703

Supplier: SABIC

Dart P/O: 7280

Packing Slip:

Yes ☒

No ☐

Invoice:

Yes ☐

No ☒

Receipt:

Cash ☐

Cr ☒

Release Note Attached:

Yes ☒

No ☐

N/A ☐

Waybill Attached:

Yes ☒

No ☐

N/A ☐

Shipment Complete:

Yes ☒

No ☐

N/A ☐

QC6 Inspection 08/10/24

N/A ☒

Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location

Costing

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 804287

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

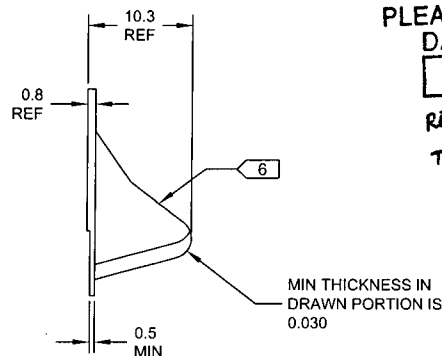
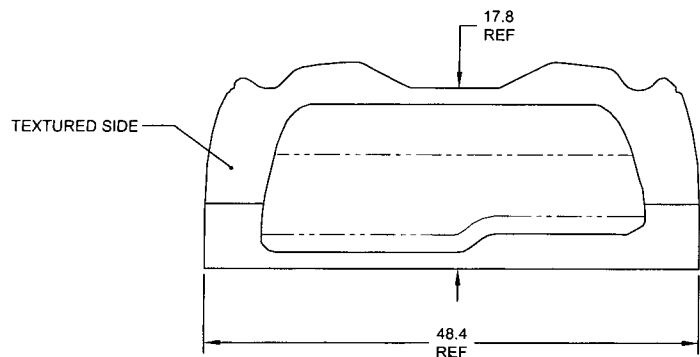
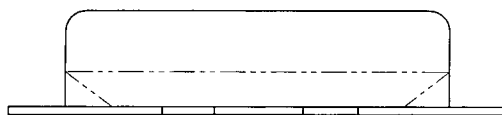
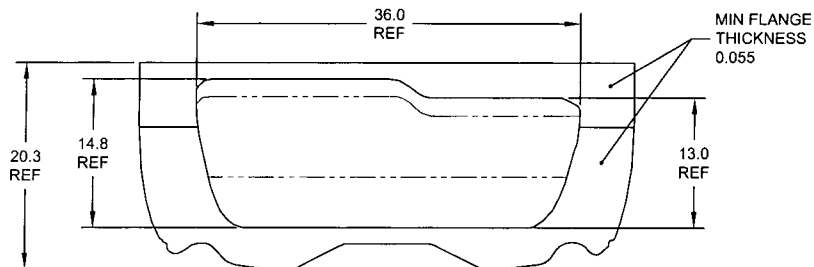
THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

8 7 6 5 4 3 2 1



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.10.22 REF
REVISED FROM 07.12.07 DWG
TO INCLUDE DIMENSIONS
UPDATE
PER FAX SHEET

D3845-1 HAT BIN
(BELL 206 L/L1)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3845-1" USING VIBRATING STYLUS
- 7) WEIGHT: 3.4 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

A NEW ISSUE		PH	08.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3845	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 L/L1)	NTS
DATE	08.10.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1